

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019868**Date Inspected:** 29-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

CWI Inspectors: Mr. Yu Jiao, Mr. Ji Cai Feng

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai China, for the purpose of monitoring welding and fabrication.

OBG Bay 14

This QA Inspector observed ZPMC welder Mr. Yan Yunfeng, stencil 215553 used shielded metal arc welding procedure WPS-345-SMAW-2G(2F)-FCM-Repair to make a weld repair of ultrasonic rejections to OBG segment 14E weld SEG3019L-1-085. ZPMC QC presented this QA Inspector with critical weld repair document B-CWR-2645 that documents this weld had been ultrasonically rejected. This QA Inspector measured a welding current of approximately 200 amps. This QA Inspector observed Mr. Yang Yunfeng appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Guo Taotao stencil 050969 used shielded metal arc welding procedure WPS-345-SMAW-3G(3F)-FCM-Repair-1 to make a weld repair of ultrasonic rejections to OBG segment 14E weld SEG3019K-011. ZPMC QC presented this QA Inspector with critical weld repair document B-CWR-2726 that documents this weld had been ultrasonically rejected. This QA Inspector measured a welding current of approximately 165 amps. This QA Inspector observed Mr. Guo Taotao appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

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This QA Inspector observed ZPMC welder Mr. Wang Zhengbin, stencil 216086 used shielded metal arc welding procedure WPS-B-P-2212-TC-U4B-FCM-1 to make OBG segment 14E weld SEG3019U-003. This QA Inspector observed ZPMC has measured a welding current of 205 amps. This QA Inspector observed Mr. Wang Zhengbin appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Zhu Jibo, stencil 055564 used flux cored welding procedure WPS-B-T-2233-ESAB to make OBG segment 13AE weld SEG3007AT-045. ZPMC QC had recorded a welding current of 247 amps and 25.2 volts. This QA Inspector observed Mr. Zhu Jibo appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Yuan Wensong, stencil 055491 used flux cored welding procedure WPS-B-T-2233-ESAB to make OBG segment 13AE welds SEG3007H-097 and 101. ZPMC QC had recorded a welding current of 253 amps and 25.1 volts. Mr. Yuan Wensong appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder stencil 037773 used flux cored welding procedure specification WPS-B-T-2133-ESAB to perform OBG segment 14E weld DP3160-001-135. This QA Inspector measured a welding current of approximately 250 amps, 26.5 volts and the base materials had been preheated with electric heating elements. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Ye Bing stencil 066733 used flux cored welding procedure specification WPS-B-T-2133-ESAB to perform OBG segment 14E weld DP3160-001-134. This QA Inspector measured a welding current of approximately 250 amps, 26.5 volts and the base materials had been preheated with electric heating elements. Items observed on this date appeared to generally comply with applicable contract documents.

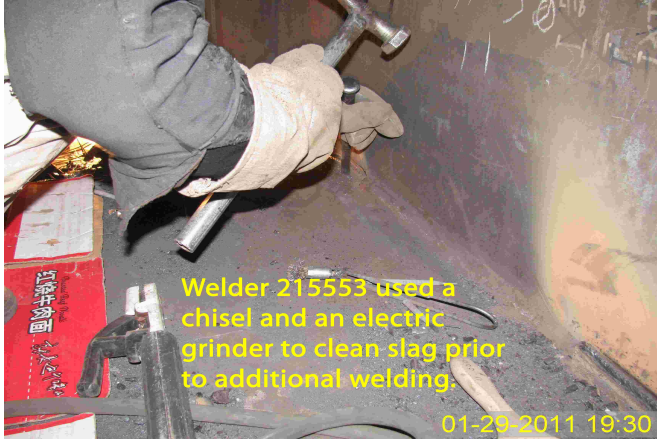
This QA Inspector observed ZPMC welder Mr. Qie Jian Zhou, stencil 067571 used shielded metal arc welding procedure specification WPS-B-P-2214-TC-U4B-FCM-1 to make OBG segment 14E weld SEG3019AG-045. This QA Inspector measured a welding current of approximately 135 amps and Mr. Qie Jian Zhou appeared to be certified to make this weld. ZPMC used electric heaters to preheat the base material of this weld joint. Items observed on this date appeared to generally comply with applicable contract documents.

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### Summary of Conversations:

See Above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey +8615000026784, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Dawson,Paul	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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